

Blue Feb 15

Work Order ID 79231

79231

January-24-12 9:55:42 AM

Page 1

Item ID: D2939-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle RH In, 206
 Start Date: 24/01/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/24 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2939	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120	QC1- Inspect dimensions to dimension sheet	0.00							
120									
QC	Memo	0.00							
Quality Control									

F.H 12/02/05

F.K 12/02/05

F.K 12/02/05

8 0

8 0

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2939-2 PAR #: _____ Fault Category: Finishing/wet paint NCR: Yes No DQA: 12/2 Date: 12/2/17
 Resolution: Rework Disposition: Rework QA: N/C Closed: 12/2 Date: 12/2/17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/09	#155	Paint has too many flows in it. R.C. Painter tried to paint too many parts at once	S 12/02/09 057012	Scuff Qty X2 Repaint as per QSI 005 in small batches	AS 12-2-9	12-02-14	S 12/02/09 057012	S 12/02/09

NOTE: Date & initial all entries

Work Order ID 79231

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January-24-12 9:55:42 AM

Item ID: D2939-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 24/01/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165	QC14- Inspect Spray Paint	0.00							
165									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 121	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

85 12-02-14 (x8)

nk/14/1/80

M.C.J 12/02/15

M.C.J 12/02/15

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 9:55:45 AM

Page 1

Work Order ID: 79231

79231

Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 24/01/2012

Required Date: 10/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	154.0000	1	8			

D6101-001

Saddle Billet

**

A.A. 12/02/02

Location

Loc Qty

Loc Code

MAT040

94

69677

2

73774

11

76836

1

→ 78158

80

8.0

MAT41

60

78598

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79231
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.132	.131	.132	.131	.131
B	0.100	0.140		.132	.131	.132	.131	.131
C	0.100	0.140		.112	.113	.112	.112	.112
D	0.210	0.230		.222	.222	.222	.221	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.260	.260	.260	.260	.260
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.236	.236	.236	.236	.236
N	0.100	0.140		.120	.120	.120	.120	.120
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510	.499	.499	.499	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.250	.250	.2500	.250
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.260	1.2595	1.2595	1.2593	1.2593
Y	1.565	1.585		1.5734	1.5744	1.573	1.573	1.573
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: E.K.	Date: 12/02/05
Audited by: B.A.	Date: 12/02/07
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79231
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

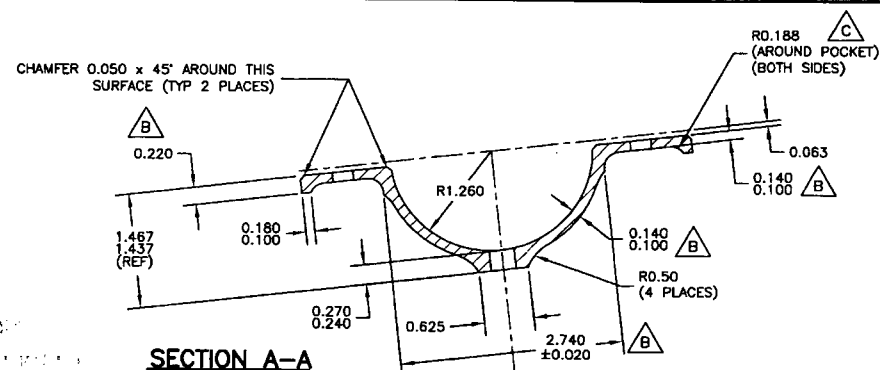
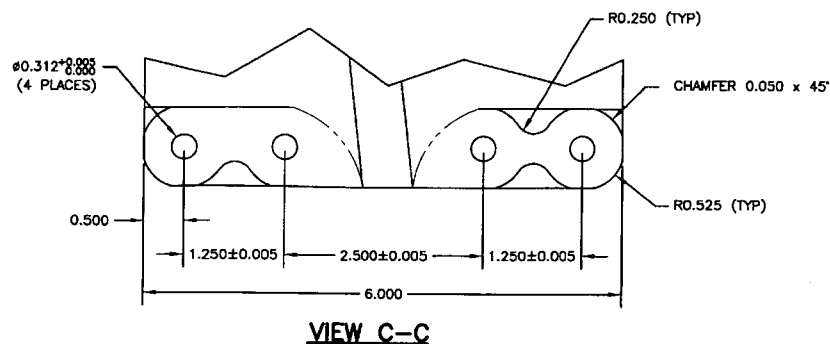
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 X	7 X	8 X	4	5
A	0.100	0.140		.131	.131	.131		
B	0.100	0.140		.131	.131	.131		
C	0.100	0.140		.112	.111	.111		
D	0.210	0.230		.222	.222	.221		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500		
K	0.257	0.262		.260	.260	.260		
L	0.312	0.317		.314	.314	.314		
M	0.235	0.240		.236	.236	.236		
N	0.100	0.140		.120	.119	.120		
O	0.540	0.560		.550	.550	.550		
P	0.490	0.510		.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740		
S	0.240	0.270		.250	.250	.250		
T	0.100	0.180		.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316		
X	1.250	1.270		1.260	1.259	1.259		
Y	1.565	1.585		1.573	1.572	1.572		
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:	F.K.	Date:	12/02/06.
Audited by:	B.A.	Date:	12/02/07
Prototype Approval:	N/A	Date:	N/A

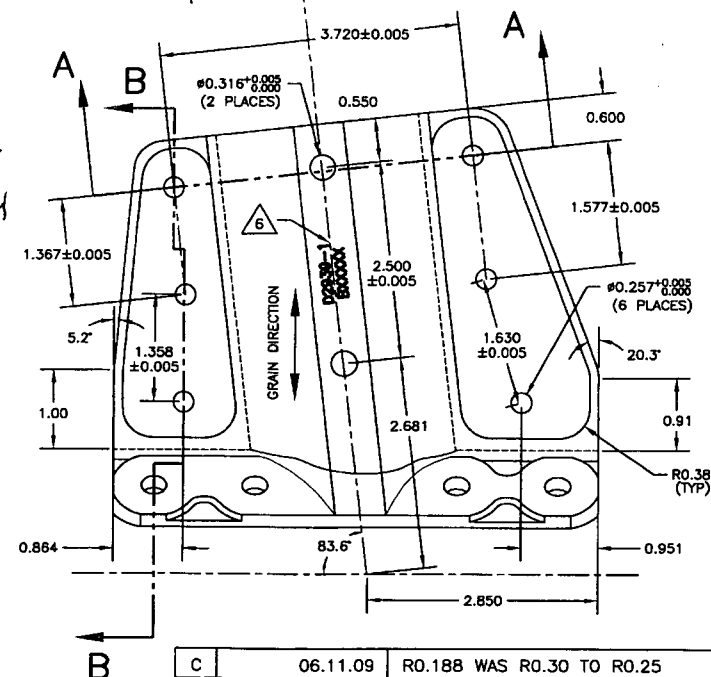
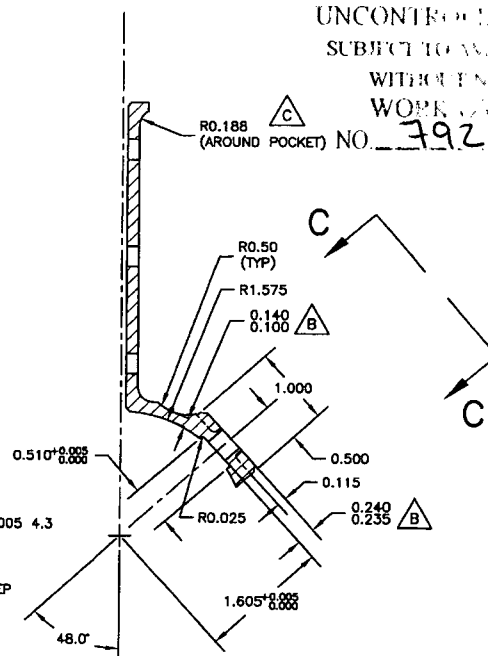
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format, Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



SHOWN
R. 0.188
ED. 0.050
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER NO. 79231 M.C.S
12/01/24

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2939
REV. C
SHEET 1 OF 1

SCALE
2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries